

# Work Order ID 51400

August 21, 2009 9:06:47 AM



Page 1

Item ID: D3371-3

FR

Accept



Setup Start



Revision ID: B

Stop



Item Name: Pedal Lock Cover

Start Date: 24/08/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 5.00

Customer:

Reference:

09/08/21

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3371

Rev B

100



BAND SAW

Bandsaw

Memo

Jcaspa Bandsaw

Cut blank: 2.00" x 2.25" x 7.370" long

0.00

0.00

09/08/21

5

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine D3371-3 as per Folio FA486 and Dwg D3371□Deburr□Finish 8-32  
thread by hand□Identify as D3371-3

0.00

0.00

09/08/22

5

1

PTO

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

0.00

09/08/23

5

W/C:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-3 PAR #: N/A Fault Category: Machine NCR: Yes No DQA: A Date: 09.08.28  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09.08.28

NCR: <u>51400</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/22	10	Origine for 2nd app was off 0.015"  e.c. B16	<u>[Signature]</u>	First part Scrap Replace 1 part B16427  correct B16 origine.	<u>DTP</u> 09/08/22	<u>8F</u> 09/08/24	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

# Work Order ID 51400

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Item ID: D3371-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Pedal Lock Cover

Start Date: 24/08/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>SS</i>	<i>09/08/24</i>		<i>5</i>			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo <i>xxx cover inside holes prior painting xxx</i>	0.00  0.00	<i>HL</i>	<i>09/08/24</i>		<i>5</i>	<i>6</i>		
<i>145</i> <i>09/08/25</i> Powder coat 150  QC Quality Control	Powder coat Fire Red per dwg <i>116102391</i> QC3- Inspect Part Finish  Memo	0.00  0.00		<i>Start time: 8:15 AM</i> <i>Oven Temp: 320°F</i> <i>Finish time: 8:45 AM</i>		<i>5</i>	<i>8</i>		
		0.00	<i>PR</i>	<i>09-08-26</i>		<i>5</i>	<i>8</i>		

**Work Order ID 51400**

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Item ID: D3371-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Pedal Lock Cover

Start Date: 24/08/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Identify as per dwg & Stock Location: 493

0.00

Memo

0.00

5 PL 8/22

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/28 PL

Quality Control

PL 09-8-27

# Picklist Print

Page 1

August 21, 2009 9:06:47 AM

Work Order ID: 51400



Parent Item: D3371-3RevB



Parent Item Name: Pedal Lock Cover

Start Date: 24/08/2009

Required Date: 04/09/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	24.0000	3.2895			



6061-T6 Bar 2.00 x 2.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

24

16427

24

3.2895' mR09/08/21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	51400
<b>Description:</b> Pedal Lock Cover		<b>Part Number:</b>	D3371-3
<b>Inspection Dwg:</b> D3371 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

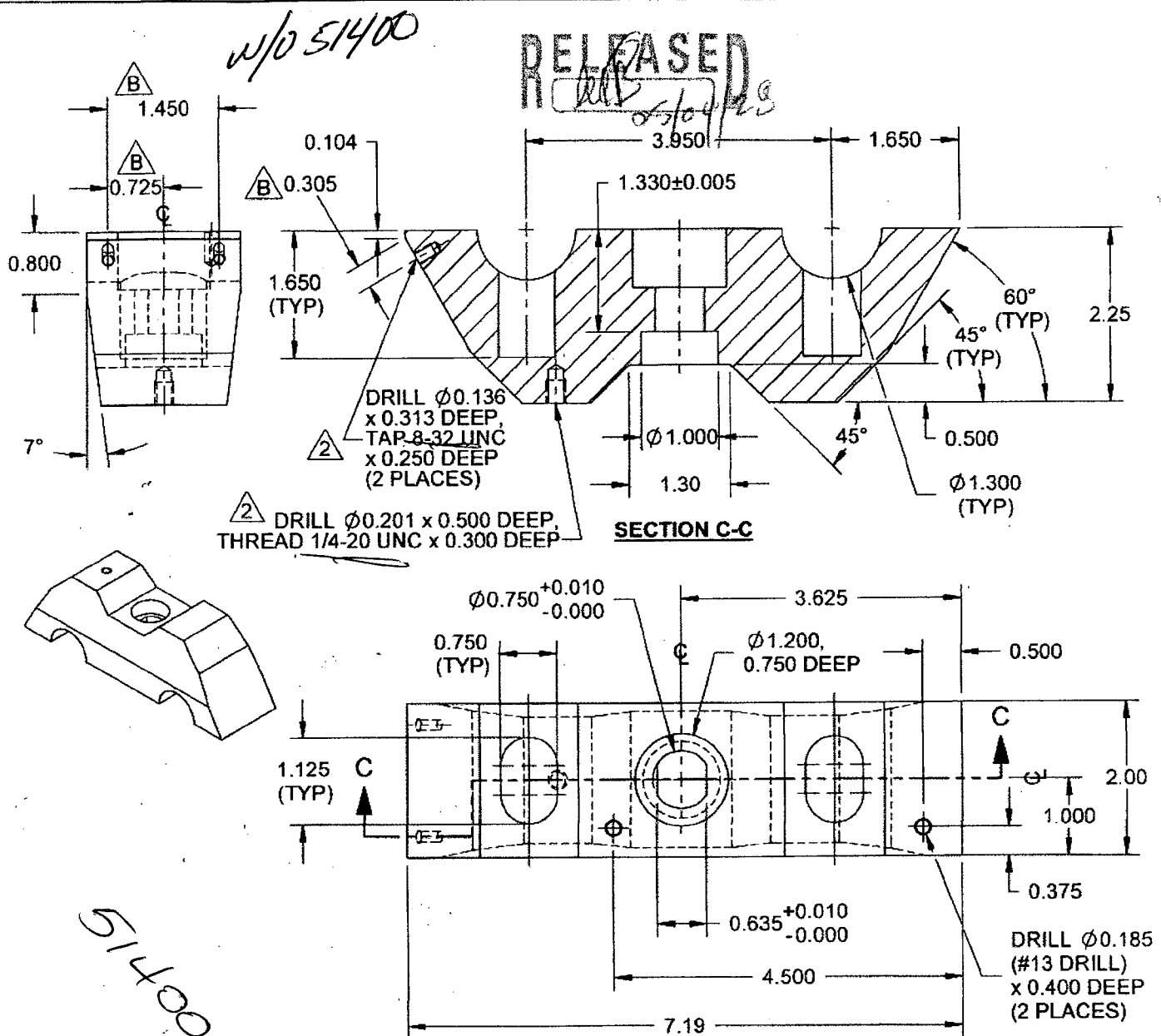
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.450	+/-0.005	1.452	✓			
7°	+/-0.5°	7°	✓			
0.104	+/-0.010	0.095	✓			
0.305	+/-0.010	0.300	✓			
1.650	+/-0.010	1.650	✓			
1.30	+/-0.030	1.300	✓			
Ø1.000	+/-0.010	1.000	✓			
45°	+/-0.5°	45°	✓			
Ø1.300	+/-0.010	1.300	✓			
0.500	+/-0.010	0.501	✓			
60°	+/-0.5°	60°	✓			
2.25	+/-0.030	2.251	✓			
1.650	+/-0.010	1.647	✓			
3.950	+/-0.010	3.954	✓			
1.330	+/-0.005	1.329	✓			
7.19	+/-0.030	7.200	✓			
4.500	+/-0.010	4.497	✓			
0.635	+0.010/-0.000	0.635	✓			
1.125	+/-0.010	1.120	✓			
0.750	+/-0.010	0.748	✓			
Ø0.750	+0.010/-0.000	0.760	✓			
3.625	+/-0.010	3.622	✓			
Ø1.200	+/-0.010	1.201	✓			
0.750 deep	+/-0.010	0.749	✓			
0.500	+/-0.010	0.498	✓			
2.00	+/-0.030	1.994	✓			
1.000	+/-0.010	1.000	✓			
0.375	+/-0.010	0.372	✓			
Ø0.185	+0.005/-0.000	0.190	✓			
0.400 deep	+/-0.010	0.410	✓			

<b>Measured by:</b>	DTP	<b>Audited by:</b>	LF	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/08/22	<b>Date:</b>	09/08/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

**DART**

DESIGN 3	DRAWN BY 3	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED *	APPROVED [Signature]	DRAWING NO. <b>D3371</b>	REV. B SHEET 3 OF 4
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>		SCALE 1:2

**D3371-3 COVER****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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